

Date: Wednesday, 1/30/2008 7:51:29 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT WEB		
Job Number	: 37052					
Estimate Number	: 10791					
P.O. Number				Part Number	: D3282041	
This Issue	: 1/30/2008		S.O. No.	Drawing Number	: D3282 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: C	
Previous Run	: 35211			Material	:	
Written By				Due Date	: 2/5/2008	
Checked & Approved By				Qty:	12	
Comment	: Est Rev:B 05.09.23 Procedure change KJ/JLM			Um:	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2792130	EXTRUSION	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)	
		Pick:	(12)
		Qty Part Number	Description
	1 D2792-130	Extrusion	Batch 33518
		Identify as D3282-1	SL 82-19
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		Cut to length as per Dwg D3282.	SL 82-19
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1-Machine as per Folio FA579 & Dwg D3282	SL 82-19 08/02/23
		2-Deburr	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SL 82-19 08/02/23
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 08/02/24 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

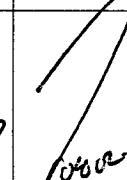
NOTE: Date & initial all entries

# Process Sheet

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Job Number: 37052		Part Number: D3282041
Job Number: 		
Seq. #:	Machine Or Operation:	Description:
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		JB 8-2-25
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		BF 08-02-25
8.0	D32831 	Doubler
Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3283-1 Doubler B 36345 24		M 8-2-27
9.0	MS20470AD47 	Rivet, Universal Head
Comment: Qty.: 57.0000 Each(s)/Unit Total : 684.0000 Each(s) Pick: Qty Part Number Description Batch 57 MS20470AD4-7 Rivet M 105940 (690)		8-2-27
10.0	LANDING GEAR 1 	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1  1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web A/RN/ALPS-3 M 104929		8-2-27
11.0	QC5 	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		8-2-28 (712)
12.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 66		8-3-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/04  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/27	9.0	- 1 rivet had to be removed, and the hole became slightly oversized.  R.C: Human error.	 081012	Replace rivet, Qty 1 with, <u>MS 20470 WS-7</u> <u>M 2655</u> MS 20470ADS-7	ll 3-2-27	 080227	 081012	 080227

NOTE: Date & initial all entries

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Job Number: 37052		Part Number: D3282041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
13.0	QC21	FINAL INSPECTION/W/O RELEASE
		 (12)
Comment: FINAL INSPECTION/W/O RELEASE		2008/03/04
Job Completion		<u>2008/3/04</u> (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37052
Description: Float Web	Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

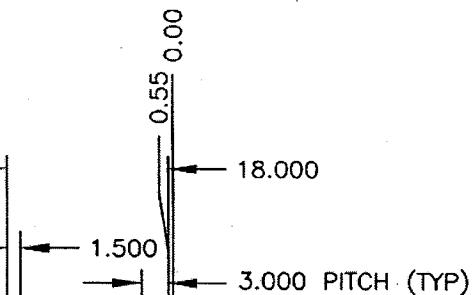
## X First Article Prototype

Measured by:	<u>Amber</u>	Audited by:	<u>J-F</u>	Prototype Approval:	N/A
Date:	08/02/23	Date:	08/02/24	Date:	N/A

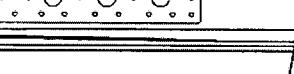
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>W</i>	APPROVED	<i>W</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		SHEET	1 OF 2	SCALE



D3283-1 DOUBLER (2)  
MS20470AD4-7 RIVET (57)  
INSTALL WITH LPS-3,  
SEE DETAIL D



**DETAIL D**  
SCALE 1:5

RELEASED  
05.09.12  
*W*

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

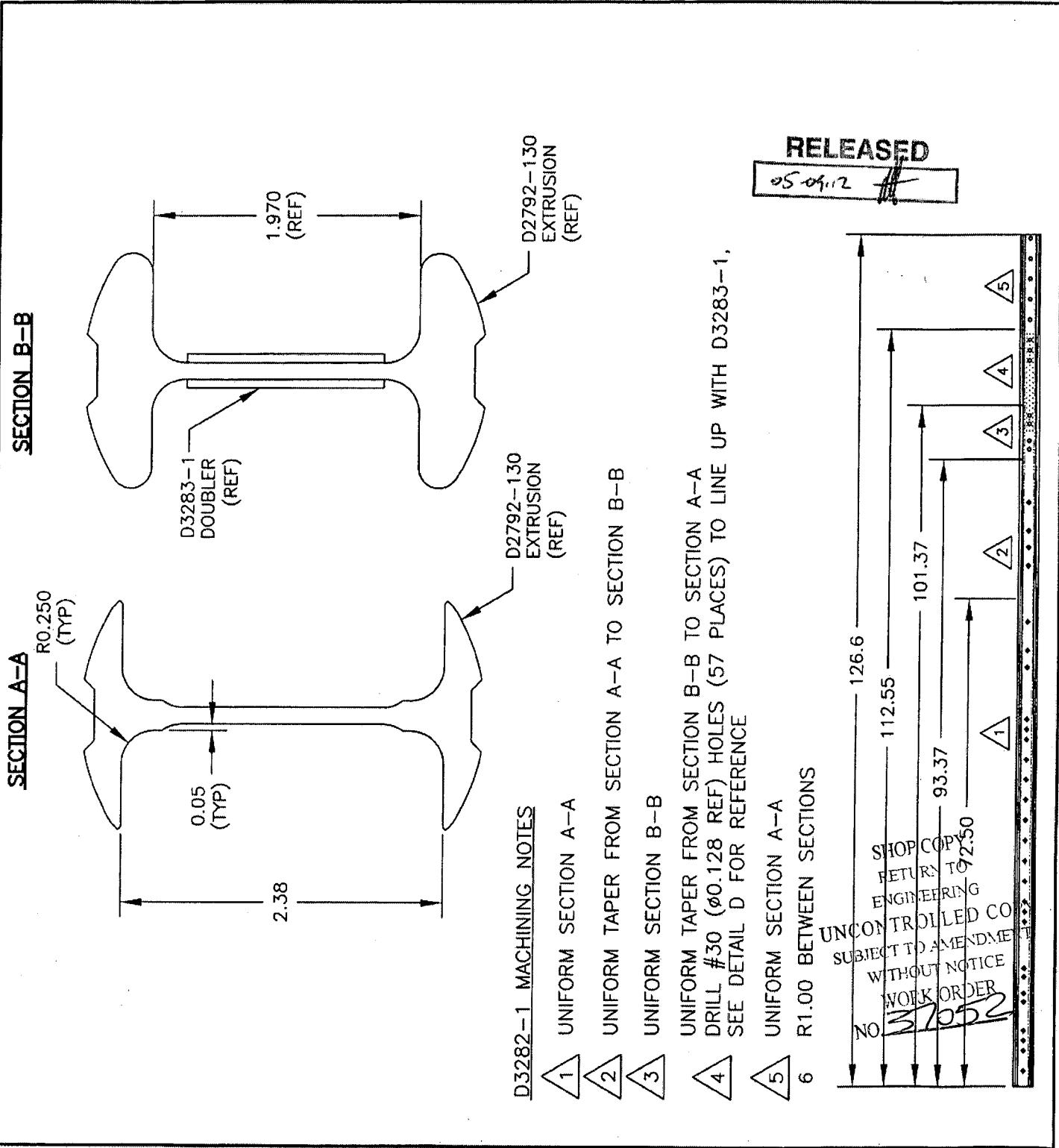
NO. 2  
*W*

#### **D3282-041 FLOAT WEB**

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3282
DATE	05.08.09	REV. C SHEET 2 OF 2 TITLE SCALE 1:20 FLOAT WEB, 206L/407



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